

Date: Monday, 18/06/2007 1:48:32 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 32924
 Estimate Number : 12908
 P.O. Number : *N/A*
 This Issue : 18/06/2007 S.O. No. : *N/A*
 Prsht Rev. : NC
 First Issue : *N/A* Type : PURCHASED PARTS
 Previous Run : *N/A*
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]*
 Comment : Est Rev:A New Issue 07-05-28 JLM

Drawing Name : CUPPED WASHER

Part Number : D36283
 Drawing Number : ~~UNDER REVIEW~~ *REV B* *LE*
 Project Number : N/A
 Drawing Revision : ~~REV B~~ *07.08.23*
 Material : *N/A*
 Due Date : 29/06/2007 Qty: 500 Um: Each

Additional Product

POSITIVE RECALL

EFFECTIVE *07-06-18* AUTH *[Signature]*
 RELEASED *[Signature]* DATE *07-08-23*

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: Issue P/O: *3997*

Email or Ship DXF file to vendor

Laser Cut D3628-1 flat pattern and form as per Dwg D3628

Possible Supplier: GFI

Material release note is required

CL07/06/18

(500)

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

7/8/21 SD

3.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

En 07/08/23

counts
(X502)

4.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

N/A per Rev. B

5.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CUPPED WASHER

Job Number: 32924

Part Number: D36283

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker on under side of part, then Stock

Location: 137

7/8/25 SO

500x

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

500x
7/8/25 SO

Job Completion



U 7-08-27

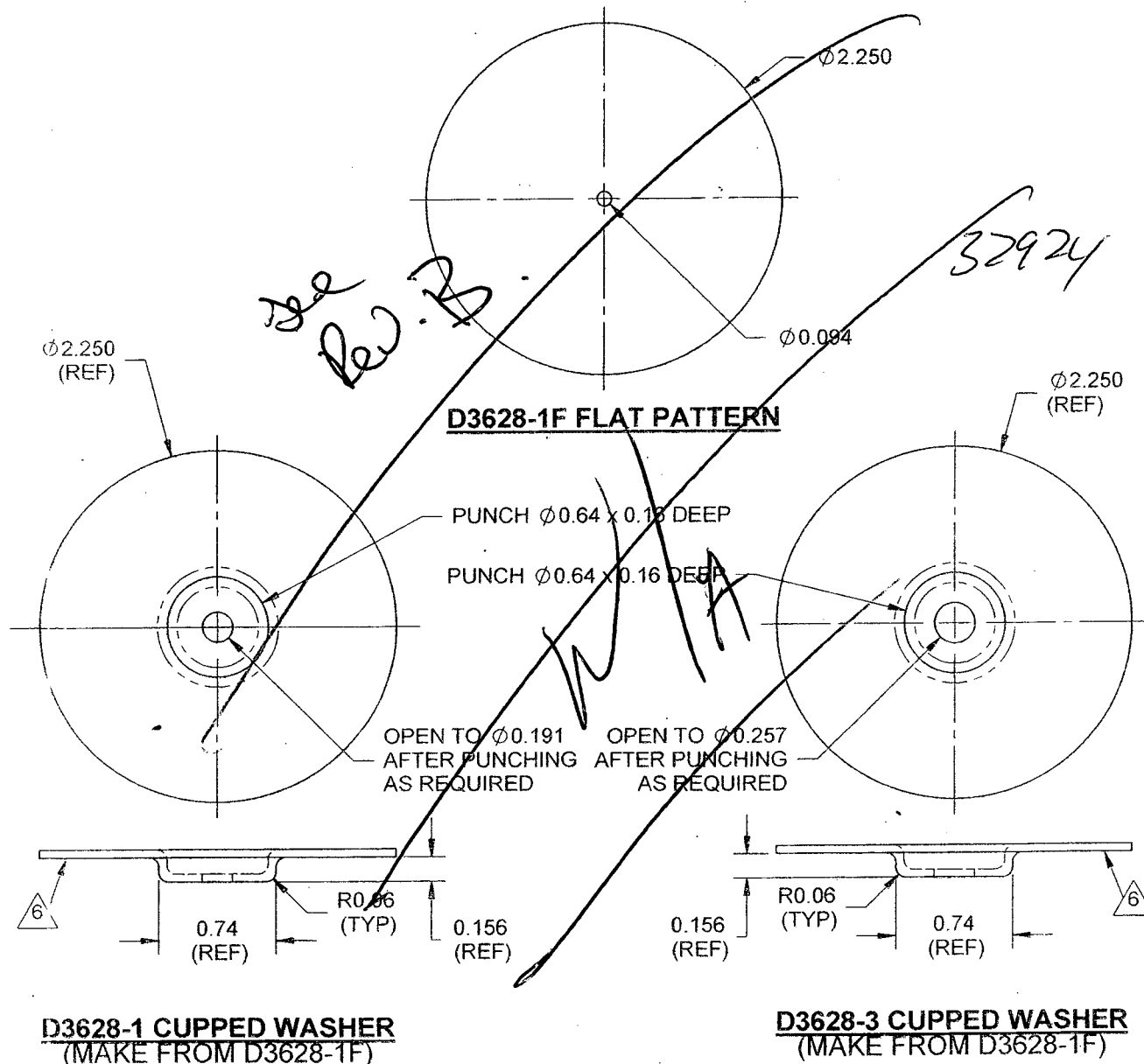
POSITIVE RECALL

EFFECTIVE _____ AUTH _____

RELEASED U DATE 7-08-27

NOT APPROVED

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED	DRAWING NO. D3628	REV. A SHEET 1 OF 1
DATE 07.06.08	TITLE CUPPED WASHER		SCALE 1:1
REV A	DATE 07.06.08	DESCRIPTION NEW ISSUE	



NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK)
PER MIL-S-5019 (REF DART SPEC M304S18GA)
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D3628-1/-3" USING FINE POINT PERMANENT INK
MARKER ON THE UNDERSIDE OF THE PART AS INDICATED

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CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE



Membre de / A M mber of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. 1		OUR JOB NO. J0164837		SHIPPING MEMO 0371767	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV.	NAME
500 PCS	PO00003997	D36283	A	CUPPED WASHER	A
MATERIAL		SUPPLIED BY		MAT. REL. NO.	
AMS 5513 304 ANN		SIGMA METALS / AK STEEL		H/N # 7360610	

#	PROCESS	PROCESSOR	RELEASE NOTE #
1	FIRST ARTICLE INSPECTION REPORT ON FILE	GFI	CONFORMS
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE **17 AUGUST 2007**

G.F.I. Q.C. REP.





AK Steel Corporation
Metallurgical Test Report
Coshocton Works
Coshocton, OH 43812

Page 1

Load No. 7981111
 SRN No. 7981111

MILL ORDER NO. 271940-0562
 PROCESSOR ORDER NO. 01008677

PART NO.
 11104

ENGLISH UNITS --PRODUCT-- METRIC UNITS
 .0500 NOM 36.0000 X COIL

RE

SKID ID	PIECE	HEAT	PARENT COIL ID	NET WEIGHT
SKID764582	1	7360610	0733066-07A	13,345 LBS. 4,063 KG.
SKID764583	1	7360610	0733066-07A	13,425 LBS. 5,908 KG.
TOTAL SKIDS	TOTAL PIECES			TOTAL NET WEIGHT
2	2			26,770 LBS. 11,961 KG.

L-Ladle Analysis of Heat

P-Product Analysis of Parent Coil

CHEMICAL ANALYSIS

ID	C	MN	P	S	SI	CR	NI	MO	N	CU						
L 7360610	.013	1.31	.025	.001	.46	18.43	8.71	.23	.037	.24						

SHIPPING DATE: 06/22/2006

REMARKS:

THIS MATERIAL WAS MELTED AND MANUFACTURED IN THE U.S.A.
 NO INTENTIONAL ADDITIONS OF MERCURY OR MERCURY COMPOUNDS, RADIUM, ALPHA
 SOURCE, AND LOW MELTING ALLOYS OR ELEMENTS CAPABLE OF FORMING LOW MELTING
 ALLOYS WERE MADE THROUGHOUT THE PROCESSING OF THIS MATERIAL.
 COILED PRODUCTS CONTAIN NO WELDS
 MATERIAL MEETS REQUIREMENTS OF TYPES 304 & 304L FOR REFERENCED SPECIFICATIONS

PRODUCT DESCRIPTION

CR SHY TYPE 302/304/304L STAINLESS #2B FINISH SLIT EDGE * AMS 5513 B * ASTM A 240 -06 (UNS S30400). * AMS 5511 B * AMS 5516 B *
 ASTM A 666 -03 * MILS-5058 D-AMEND-3 * UNS-S30403 9TH EDITION * FMI-304L/304/302 ISSUE 7, 2/13/06 * ASME SA-240 SECTION II PAR
 T A (2004 ED, 2005 ADDENDA) EX PARA 3.1.7 DIMENSIONAL TOLS FROM ASME SA-480 2004 ED APPLY * UNS-S30400/S30200

PARENT COIL ID	POS (R/T)	DIR (L, T, D)	COND	% ELONG 1 INCH MEASURED	TENSILE STRENGTH (KSI)	Y.S. 2% OFFSET (KSI)	ROCKWELL HARDNESS Tol	ROCKWELL HARDNESS Front			
0733066-07A	T	T	A.S.T.M	55.3	87.2	43.3	B 79	B 79			

REVIEWED BY Q.C.

Date 6/23/06 by *Kr*

*** CONTINUED ON NEXT PAGE ***

SIGMA METALS

01 09:44 FAX 6012433426



AK Steel Corporation
Metallurgical Test Report
Coshoccon Works
Coshoccon, OH 43812

Load No. 7981111
SRN No. 7981111

MILL ORDER NO. 271940-552
PROCESSOR ORDER NO. 010067

PART NO. 010067
ENGLISH UNITS - PRODUCT: METRIC UNITS
36.0000 X COIL

PARENT COIL	POS	DIR	CUND	ASTM	GRAIN	SIZE	ASTM E112	IT	REND
ID	(U/T)	(I, I, D)		PRACTICE	E	9.50	PASS		
073066-07A	T			ASTM	PASS	9.50	PASS		
073066-07A	F			ASTM	PASS	9.50	PASS		

SIGMA METALS INC
THESE TEST REPORTS APPLY TO:

PO 0071457
B/D 10079
POS 124#
NET DATE 4-16-07

THE GENERAL ANALYSIS AND PHYSICAL OR MECHANICAL TESTS REPORTED ABOVE ARE CORRECT AS CONTAINED IN THE RECORDS OF THIS CORPORATION.
ALL TESTING IS DONE IN ACCORDANCE WITH ASTM STANDARDS UNLESS OTHERWISE NOTED.
APPROVED BY: [Signature]
DATE 04/22/07 TIME 10:34 AM
APPLICATION ENGINEER

354-07



Sigma Metals Inc.
 45 Jefryn Blvd.
 Deer Park, NY 11729
 A Small Woman Owned Business

(631) 243-2100 • (800) 471-7890 • Fax: (631) 243-3426

Packing Slip

DATE 4/16/2007 INVOICE NO. 43712

BILL TO
GFI INC. 180 AVENUE LABROSSE POINT-CLAIRE QUE, CANADA H9R 1A1

SHIP TO
GFI INC. 180 AVENUE LABROSSE POINT-CLAIRE QUE, CANADA H9R 1A1

P.O. NO.	TERMS	REP	SHIP VIA	FOB	SALES ORDER
0071457	Net 30	MEC	YELLOW	DEER PARK, NY	60791

ITEM	DESCRIPTION	QTY	
MISC	304 ANNEALED SHEET AMS 5513 QQS 766 050" X 36" X 120" 124 LBS. MILL: AK STEEL LOT #7360610 PRICED PER PC	2	
	DOMESTIC CUSHPAK	1	
<div style="display: flex; justify-content: space-between;"> <div> <p>PACKING</p> </div> <div> <p>GFI INC.</p> <p>LE MATERIEL REÇU NE SERA ACCEPTE L'APRES VÉRIFICATION DE DIMENSIONS, L'EPaisseur, POIDS ET CONDITIONS.</p> <p>SIGNATURE <u>Saladino</u> DATE <u>20 APR 07</u></p> <p>CERTIFICATE OF COMPLIANCE</p> <p>THE WILLFUL RECORDING OF FALSE, FICTITIOUS OR FRAUDULENT STATEMENTS ON THIS DOCUMENT MAY RESULT IN PUNISHMENT AS A FELONY UNDER FEDERAL STATUTES. THIS DOCUMENT CERTIFIES THAT ALL ITEMS NOTED ABOVE ARE IN CONFORMANCE WITH THE CONTRACT DRAWINGS, SPECIFICATIONS AND OTHER DOCUMENTATION. ALL REQUIRED PROCESS CERTIFICATION AND CHEMICAL AND PHYSICAL TEST REPORTS ARE ON FILE IN THE FACILITY AND ARE SUBJECT TO REVIEW.</p> <p>THIS MATERIAL MEETS ALL SPECIFICATIONS LISTED.</p> <p>GREG SALADINO QC <u>Gregory Saladino</u> Quality Control Manager</p> </div> </div>			

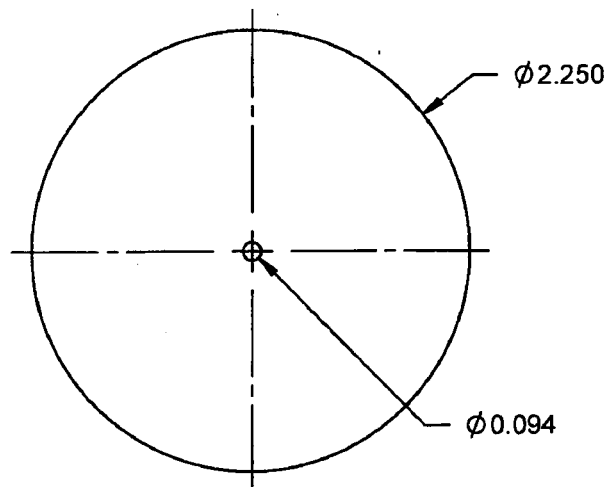
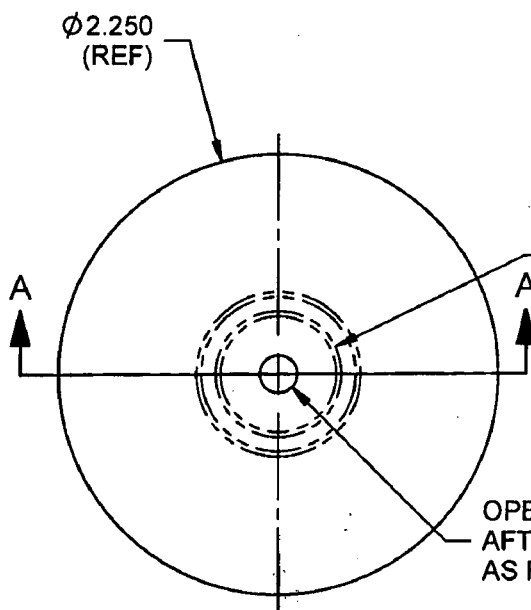
ORDER COMPLETE TEST REPORTS WITH SHIPMENT
 WE NOW ACCEPT VISA, MASTERCARD, AND AMERICAN EXPRESS

DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED [Signature]	DRAWING NO. D3628	REV. B SHEET 1 OF 1
DATE 07.07.09	TITLE CUPPED WASHER		SCALE 1:1
REV A	DATE 07.06.08	DESCRIPTION NEW ISSUE	
B	07.07.09	REMOVE POWDER COAT	

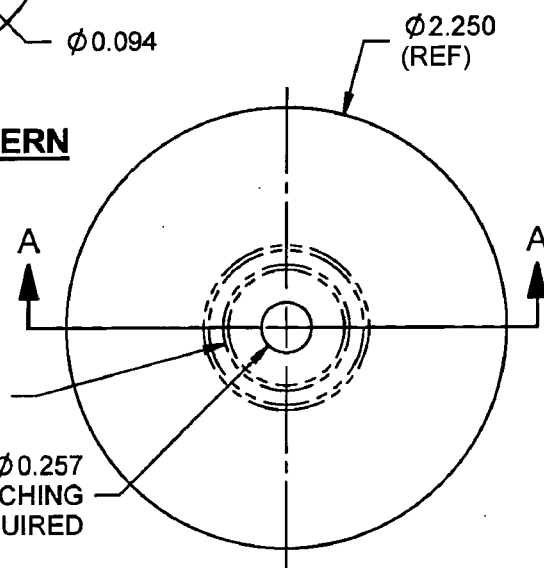
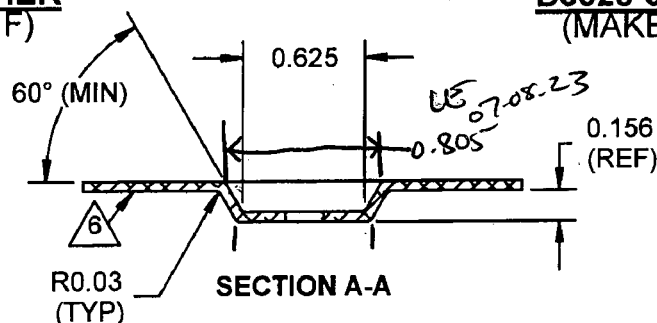
RELEASED

07.07.09

only change from REV A to B.**D3628-1F FLAT PATTERN****D3628-1 CUPPED WASHER**
(MAKE FROM D3628-1F)

PUNCH Ø0.64 x 0.16 DEEP

PUNCH Ø0.64 x 0.16 DEEP

OPEN TO Ø0.191
AFTER PUNCHING
AS REQUIREDOPEN TO Ø0.257
AFTER PUNCHING
AS REQUIRED**D3628-3 CUPPED WASHER**
(MAKE FROM D3628-1F)**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK) PER MIL-S-5019 (REF DART SPEC M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D3628-1/-3" USING FINE POINT PERMANENT INK MARKER ON THE UNDERSIDE OF THE PART AS INDICATED
- 7) WHEN DRILLING OUT THE CENTRE HOLE AFTER PUNCHING, ENSURE THAT THE HOLE IS DRILLED CONCENTRIC TO THE CUPPED AREA, WITHIN 0.03

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